

Date: Tuesday, 12/4/2007 7:40:48 AM
 User: Chantal Lavoie

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LITTER ASSEMBLY		
Job Number	36094			Part Number	D2370		
Estimate Number	10301			Drawing Number	D2370 REV C		
P.O. Number	:			Project Number	N/A		
This Issue	12/4/2007	S.O. No.	:	Drawing Revision	C		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	PURCHASED PARTS	Due Date	12/11/2007		
Previous Run	34932			Qty:	<i>6</i>		
Written By	:			Um:	Each		
Checked & Approved By	:						
Comment	Est D 01.10.10 Changed D2484 nut for D3015-1 SM est E 06.12.12 ecn 888 ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue p/o: <i>5179</i>	<i>CX67112104</i>
		Order: Model 12-2A undrilled with grey pad & black belts	
		Supplier: Ferno Aviation	
		Letter of compliance required	
2.0	D2370P	Litter Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Litter Assembly	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage Insure that letter of compliance is attached to w/o	<i>Res/1/21(6)</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<i>Cos/01/21 (6)</i>
5.0	D2374	Stud	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Stud Pick: Qty Part Number Description Batch	<i>B31345 81/21 300 (ax)</i>
	4	D2374	Stud

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 36094

Part Number: D2370

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2378 Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
4 D2378 Mounting Bolt *161*

136103 8X

SP

7.0 D30151 Lock Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lock Nut

Pick:

Qty Part Number Description Batch
4 D3015-1 Lock Nut *161*

SP

8.0 AN960JD416L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
4 AN960JD416L Washer *161*

SP

9.0 MS27039406 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Batch: *1106541*

8/1/21 SP 6X

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



POSITIVE RECALL

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2370

2-Drill 0.191" holes as per Dwg D2370

FF 08-01-22

6

3-Replace lose rivets with screw per dwg D2370

Apply locktite *M104483*

3-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: LITTER ASSEMBLY	
Job Number: 36094	Part Number: D2370	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	QC5	INSPECT WORK TO CURRENT STEP
		08/01/22 (6)
Comment: INSPECT WORK TO CURRENT STEP		
12.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: _____ 08/01/22 (6)		
13.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/01/22 (6)
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion	 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

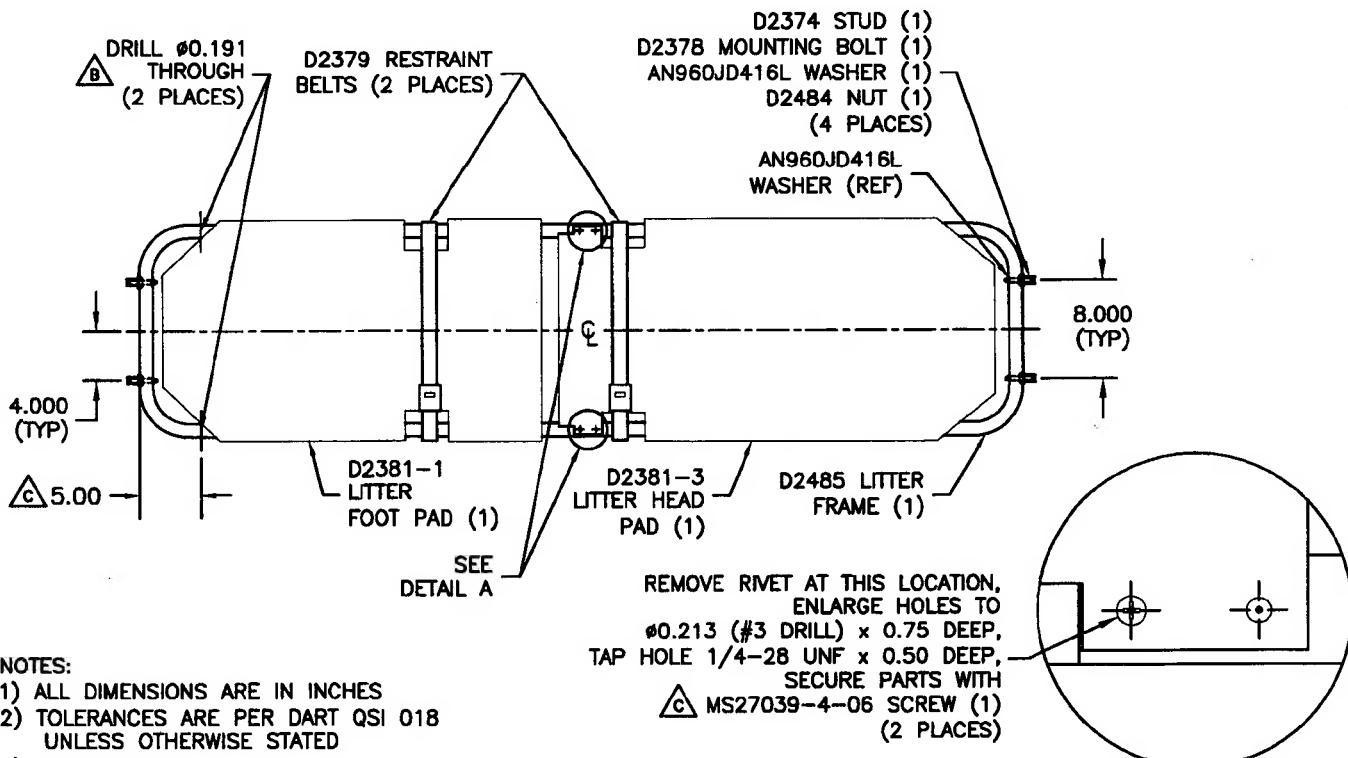
NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D2370
DATE 06.11.21		REV. C SHEET 1 OF 1
		TITLE LITTER ASSEMBLY
A	95.02.20	SCALE NTS
B	98.06.09	ADDED Ø0.191 HOLES
C	06.11.21	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES, AND 5.00 WAS 5.34

RELEASED
06 12.05 44

D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
4	D2374	STUD
4	D2378	MOUNTING BOLT
2	D2379	RESTRAINT BELTS
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (OR D3015-1) /C
1	D2485	LITTER FRAME
4	AN960JD416L	WASHER
2	MS27039-4-06	SCREW /C

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE STATED
- 3) FINISH: NONE
- 4) TORQUE SCREWS TO 15-25 in-lb
- 5) REMOVE ALL SHARP EDGES 0.010 TO 0.020 MAX

DETAIL A
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UJ036094
CL07/12/04



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Visit us at our web site: www.ferno.com

21 January, 2008

Certificate of Conformance

Manufacturer: Ferno-Washington Inc.

Manufacture Address: 70 Weil Way
Wilmington, Ohio USA

Order No. C- 830347

P.O. # Ferno Aviation - PO#: 4669
Dart Aerospace LTD - PO#: ~~5170~~ 5174

Model: 12-2 Stretcher - Gray

Item Number: Ferno-Washington # 0163255
Dart Aerospace LTD #

Serial Nos. 08 070231, 08 070232, 08 070233, 08 070234, 08 070235, 08 070236

I certify that the above referenced products are produced in accordance with applicable Ferno-Washington Inc. engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices.

Ferno-Washington Inc. is a registered manufacturer (Registration No. 1523574) with the United States Food and Drug Administration (FDA) as a manufacturer of medical devices, and the Quality Management System has been verified by the FDA to be in compliance to FDA's Code of Federal Regulations 21 Part 820.

Ferno-Washington, Inc. maintains a Quality Management System that fulfills the requirements of DIN EN ISO 9001:2000, ISO 13485:2003 and CMDCAS (Canadian Medical Devices Conformity Assessment System). Copies of Ferno-Washington, Inc.'s ISO 9001:2000 and ISO 13485 certificates issued by DQS GmbH are available upon request.

Thomas E. Livingston
Director of Quality